

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011585**Date Inspected:** 10-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** Mr.Liu Fa Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

BAY-5 -Traveler Rail (TR)

This QA Inspector observed the following work in progress:

Flux Cored Arc Welding (FCAW) welding of welds joint 014 located on 11TR1-020. Welder is identified as 250353. ZPMC Quality Control (QC) is identified as Mr.Shenjian Guo. The welding variables recorded by QC appeared to comply with the Applicable WPS: B-T-2232-TC-U5-F.

Flux Cored Arc Welding(FCAW)welding of weld joint 014 located on 10TR3-006. Welder is identified as 204342. ZPMC Quality Control (QC) is identified as Mr.Shenjian Guo . The welding variables recorded by QC appeared to comply with the Applicable WPS: B-T-2232-TC-U5-F.

Flux Cored Arc Welding (FCAW)welding of weld joint 012 located on 11TR-001. Welder is identified as 215689. ZPMC Quality Control (QC) is identified as Mr.Shenjian Guo. The welding variables recorded by QC appeared to comply with the Applicable WPS: B-T-2132.

BAY-7-Traveler Rail (TR)

WELDING INSPECTION REPORT

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Flux Cored Arc Welding (FCAW) welding of weld joint 001/005/009 located on 22TR4-002. Welder is identified as 066695/068859/066471. ZPMC Quality Control(QC) is identified as Mr.Zhou Joe. The welding variables recorded by QC appeared to comply with the Applicable WPS:B-T-2232-TC-U5-F.

Flux Cored Arc Welding (FCAW) welding of welds joint 007 located on 22TR3-002. Welder is identified as 066734. ZPMC Quality Control (QC) is identified as Mr.Zhou Joe. The welding variables recorded by QC appeared to comply with the Applicable WPS: B-T-2232-TC-U5-F.

Flux Cored Arc Welding (FCAW) welding of weld joint 003 located on 22TR4-002. Welder is identified as 066695. ZPMC Quality Control (QC) is identified as Mr.Zhou Joe. The welding variables recorded by QC appeared to comply with the Applicable WPS: B-T-2232-TC-U5-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and Quality Control (QC) concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhu,Surendra	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
